

Work Order ID 95516

95516

Page 1

Thursday, January 10, 2013 11:40:50 AM

Item ID: D4642-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Glareshield Retainer

Stop *NS2*

Start Date: 1/10/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/11/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

MMF

Date: 13-1-10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4642

PAT Rev. A

*ASS
13.01.11*

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dwg

Prog rev: *A*

Dwg rev: *A*

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

Eng Use Only

2
4

Im 13-1-11

2
9

Im 13-1-11

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Page 2

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

13-01-14

4

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

13/01/14

DAS
15
2-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

13214

4

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2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

170

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

170

Powdercoat

Memo

0.00

Powder Coating

mf
13-1-10

Work Order ID 95516***95516***

Page 4

Thursday, January 10, 2013 11:40:50 AM

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Start Date: 1/10/2013 Start Qty: 2.00

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Cust Item ID:

Required Date: 1/11/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: _____

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

*bug to
Dan Stow**charge to
RD4392**MF
13-1-31*

Picklist Print

Thursday, January 10, 2013 11:40:50 AM

Page 1

Work Order ID: 95516

Parent Item: D4642-3

Parent Item Name: Glareshield Retainer

Start Date: 1/10/2013

Required Date: 1/11/2013

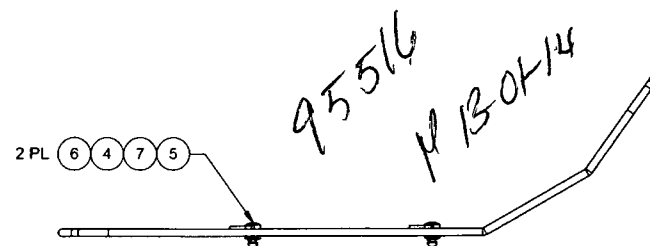
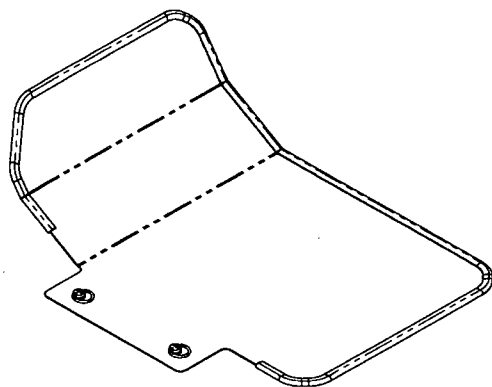
Start Qty: 2.00

Required Qty: 2.00

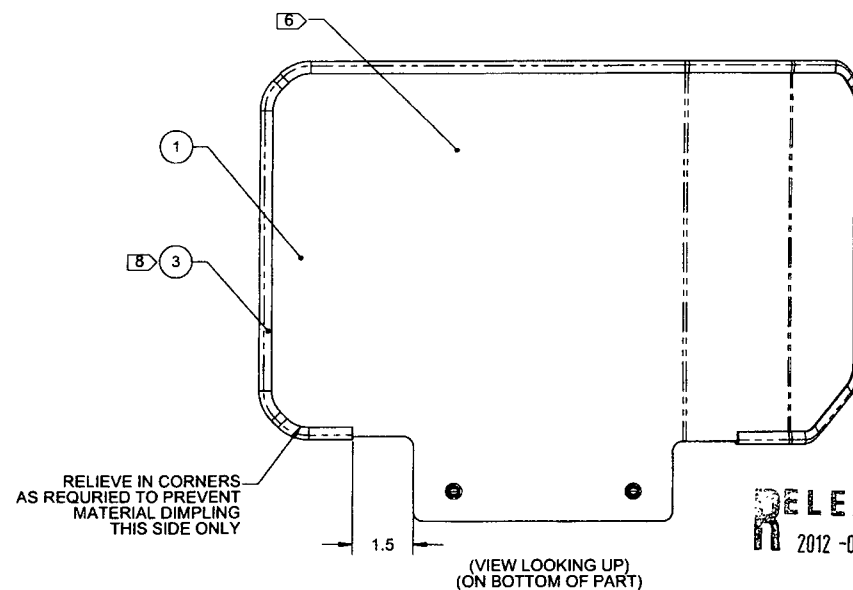
Comments: IPP revA 12.05.08 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No				sf	151.7162		1235 84			Jm B-1-11
				<u>Location</u>				<u>Loc Qty</u>					
				MAT021				151.7161578					
					121473			0.9161578					
					123279			150.8		123279			

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION	SUPPLIER
	X		D4642-041	GLARESHIELD ASSY	
		X	D4642-042	GLARESHIELD ASSY	
1	1		D4642-1	GLARESHIELD	
2		1	D4642-2	GLARESHIELD	
3	1	1	D4642-5	CHAFE GUARD	
4	2	2	43-13-1-24	EJECTOR SPRING	SOUTHCO
5	2	2	82-15-160-16	1/4 TURN STUD	SOUTHCO
6	2	2	82-32-201-20	RETAINER	SOUTHCO
7	2	2	82-46-101-41	WEAR WASHER	SOUTHCO



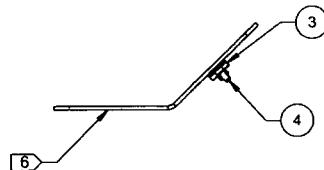
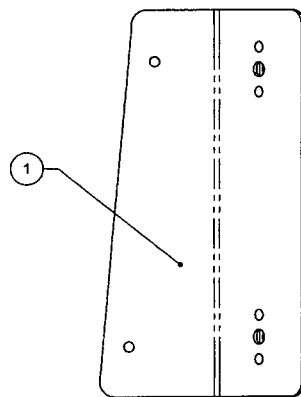
D4642-041 GLARESHIELD ASSY (SHOWN)
D4642-042 GLARESHIELD ASSY (OPPOSITE)



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4642-04X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
 - 7) WEIGHT: 0.58 lbs
 - 8) BOND ITEM 3 IN PLACE USING 3M, 1357 CONTACT CEMENT

A		NEW ISSUE		AJS	12.03.23
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4642 TITLE GLARESHIELD		REV. A	
DRAWN	AJS			SHEET 1 OF 4	
CHECKED	JP			SCALE	
MFG. APPR.	JP			NTS	
APPROVED	JP				
DE APPR.	JP				
DATE		12.03.23		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

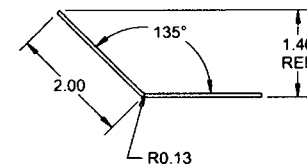
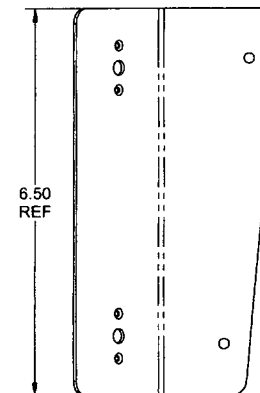
ITEM	QTY -043	QTY -044	P/N	DESCRIPTION	SUPPLIER
	X		D4642-043	GLARESHIELD RETAINER ASSY	
		X	D4642-044	GLARESHIELD RETAINER ASSY	
1	1		D4642-3	GLARESHIELD RETAINER	
2		1	D4642-4	GLARESHIELD RETAINER	
3	2	2	82-35-302-15	1/4 TURN RECEPTACLE	SOUTHCO
4	4	4	MS20426AD3-6	RIVET, CSK	



D4642-043 GLARESHIELD RETAINER ASSY (SHOWN)
D4642-044 GLARESHIELD RETAINER ASSY (OPPOSITE)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4642-04X" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.15 lbs



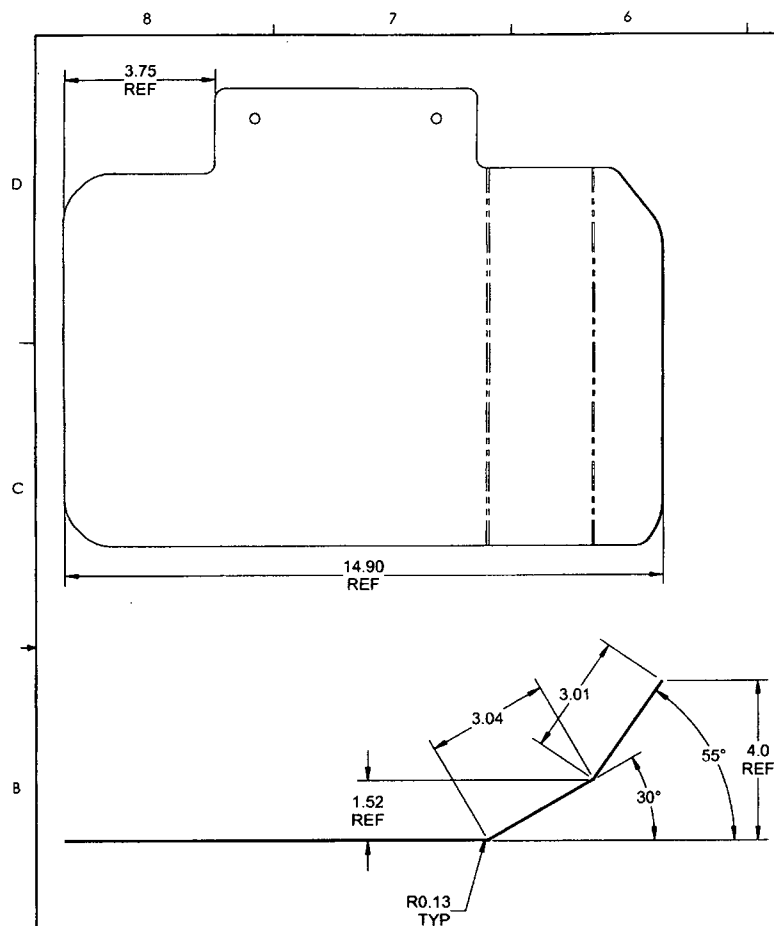
D4642-3 GLARESHIELD RETAINER (SHOWN)
D4642-4 GLARESHIELD RETAINER (OPPOSITE)

NOTES:

- 1) MATERIAL: MAKE FROM D4642-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS GREY (ANSI 61 GREY) (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs

RELEASED
2012-06-13

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4642	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	GLARESHIELD	NTS
DATE	12.03.23	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

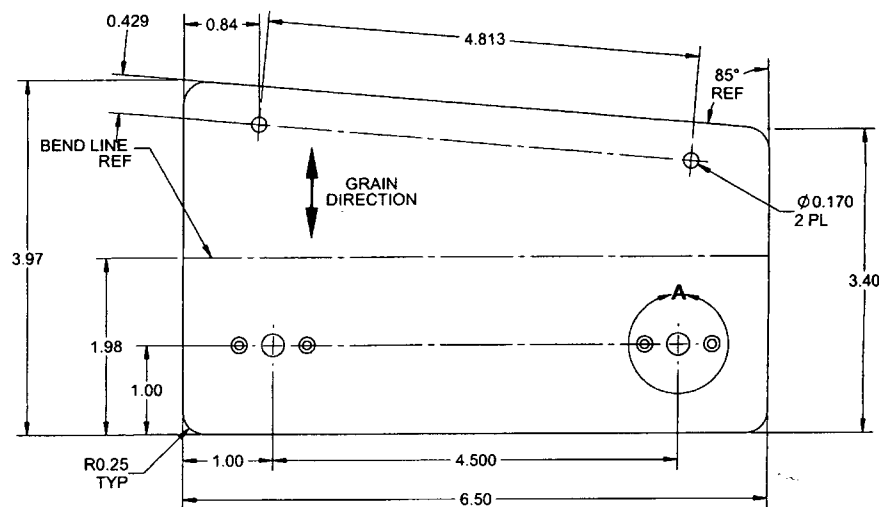


D4642-1 GLARESHIELD (SHOWN)

D4642-2 GLARESHIELD (OPPOSITE)

NOTES:

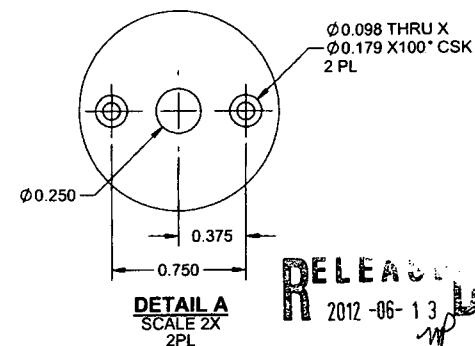
- 1) MATERIAL: MAKE FROM D4642-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs



D4642-3F GLARESHIELD RETAINER
(FLAT PATTERN)

NOTES:

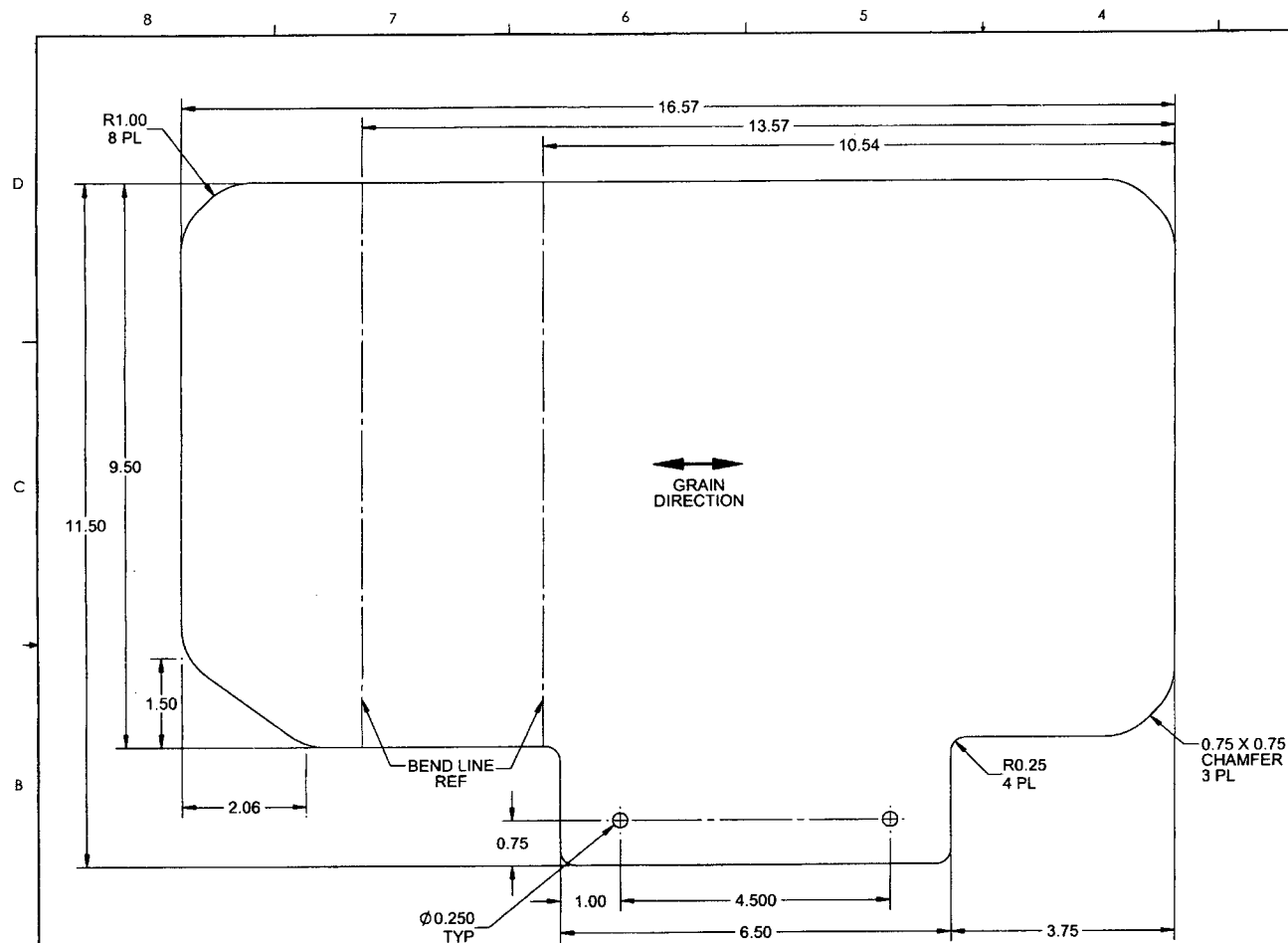
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs



DETAIL A
SCALE 2X
2PL

RELEASE
2012-06-13

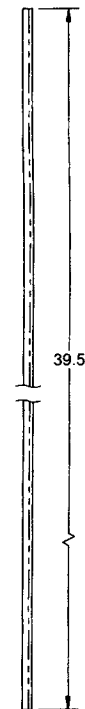
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	BE	D4642	SHEET 3 OF 4
APPROVED	149	TITLE	SCALE
DE APPR.	A	GLARESHIELD	NTS.
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D4642-1F GLARESHIELD
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.52 lbs



D4642-5 CHAFE GUARD

RELEASE
2012-06-10

NOTES:

- 1) MATERIAL: MAKE FROM D3555-1-035.50
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4642	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GLARESHIELD	NTS
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